



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3049-1

Job Sheet 181213



Part No: D3049-1

Job Qty: 6 ea

DAS
21
9-89

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		18/07/30
110	Waterjet	6 pcs	8/31/18	8/31/18	0.00	1.79	Waterjet1		18/07/30
120	CNC Vertical Machining	6 pcs	8/31/18	8/31/18	0.21	7.32	HAAS1-3		18/08/23
130	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-1		18/08/23
140	QC	6 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-1		18/08/23
170	Packaging	6 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3		18/08/25
180	QC21-SA	6 Ea	8/31/18	8/31/18	0.00	0.00	QC21		18/08/25

Part Op 110 - CUT BLANK AS PER FILE D3049-1_BLANK

Descriptions: 120 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	20.4000 sf (3.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	20	1,173	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	0.260	Diameter
2	Bearpaw	0.930Inches ± 0.030	0.960 0.900	0.930	
3	Bearpaw	0.400Inches + 0.030 - 0.000	0.430 0.400	0.410	
4	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000	
5	Bearpaw	10.310Inches ± 0.010	10.320 10.300	10.310	
6	Bearpaw	2.870Inches ± 0.030	2.900	2.870	

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

 Part: D3049 - 1 Job No: 181213 Serial No/Batch: S097684 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's	Completed By _____	
	Lead hand / Supervisor Approval Verification _____	
	QC / QA Coordinator Approval _____	
	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/30/18	

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____		Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
--	--	--	--	---	--	--	--	--	--	--	--

			2.840	
7	Bearpaw	8.000Inches ± 0.030	8.030 7.970	8.000
8	Bearpaw	0.380Inches ± 0.030	0.410 0.350	0.375
	Bearpaw	11.500Inches ± 0.030	11.530 11.470	11.500
10	Bearpaw	0.070Inches ± 0.030	0.100 0.040	.085
11	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45° Angle
12	Bearpaw	0.440Inches $+ 0.030$ $- 0.000$	0.470 0.440	0.448
13	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250 Radius
14	Bearpaw	0.950Inches $+ 0.030$ $- 0.010$	0.980 0.940	0.952
15	Bearpaw	0.690Inches ± 0.030	0.720 0.660	0.692
16	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.188
17	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250 Radius
18	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250
19	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	45° Angle

DIP 18-08-22

Plex 7/24/18 9:25 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					